



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

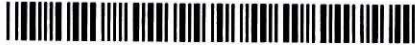
D3488-041
Job Sheet 179050



Part No: D3488-041

Job Qty: 20 ea

Part Name: Blade Fitting LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSK101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Machining-2		DL 18/07/17
100	Doosan	20 pcs	7/2/18	7/2/18	0.00	17.09	Doosan		DL 18/07/17
110	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Machining-2		DL 18/07/17
120	CNC Vertical Machining	20 pcs	7/2/18	7/2/18	0.34	16.53	HAAS1-3		DJP 18/07/24
130	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Machining-2		
140	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC8 Machining-2		DL 18/07/26
150	HandFinish	20 pcs	7/2/18	7/2/18	0.00	0.64	HandFinish1		DL 18-7-27
160	Powdercoat	20 pcs	7/2/18	7/2/18	0.00	0.70	Powdercoat1		DL 18-7-30
170	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC3		DL 18-7-30
180	HandFinish	20 pcs	7/2/18	7/2/18	0.00	0.00	HandFinish4		DL 18-7-30
190	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC5		DL 18-7-30
200	Packaging	20 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1	FP001	DL 18-7-30
210	QC21-SA	20 Ea	7/2/18	7/2/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625
Descriptions: 120 - 1-Machine as per Folio FA625 & Dwg D3488

160 - START TIME: 3:00 AM 3245 8:30 AM

180 - Install Inserts as per Dwg D3488

200 - LOCATION : FP001

DAS
53
9-89

JUL 30 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	20 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	80 Ea (4 ea)	180-HandFinish	5038208

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	20	44	0
180-HandFinish	ALS7-1032-225	80	1,048	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	179050
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.149"				
Ø2.780	+/-0.005	2.777"				
Ø3.125	+/-0.010	3.122"				
Ø3.346	+/-0.010	3.346"				
0.125 x 45°	+/-0.010 x +/-0.1°	.125 x 45°				
8.000	+0.030/-0.000	8.015"				
9.250	+/-0.010	9.248"				
0.188	+/-0.010	.186"				
R0.032	+/-0.010	R.032"				
R0.062	+/-0.010	R.062"				
Ø0.297	+0.005/-0.001	.300				
Ø0.430	+/-0.010	.435"				
0.100	+/-0.010	.101"				
0.125	+/-0.010	.125"				
2.620	+/-0.010	2.621"				
3.500	+/-0.010	3.501"				
1.005	+/-0.010	1.006"				
Ø0.484	+0.005/-0.001	.486"				
1.180	+/-0.010	1.179"				
3.150	+/-0.010	3.150"				
3.070	+/-0.010	3.063"				
R0.063	+/-0.010	R.063"				

DART AEROSPACE LTD		Work Order: 172050
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø.507	✓		G.P.	
0.750	+/-0.010	0.750	✓		Uer	
1.500	+/-0.010	1.500	✓		Uer	
11.18	+/-0.030	11.180	✓		H.G.	
R0.062	+/-0.010	R0.062	✓		R.G.	
0.125	+/-0.010	0.125	✓		Uer	
0.590	+/-0.010	0.582	✓		H.G.	
0.793	+/-0.010	0.794	✓		Uer	
1.351	+/-0.010	1.354	✓		H.G.	
1.317	+/-0.010	1.312	✓		Uer	
1.802	+/-0.010	1.803	✓		H.G.	

DAS
52
9-89

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 18/07/23	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	[Signature]



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Suspected Unapproved		Skid-tube	Cross tube	Water Jet	Engineering
Use-as-is		Machining	Small Fab	Prod. Eng. Coord.	Quality
Rework		Thermoforming	Finishing	Rec/Store/Packaging	Other
Scrap		Large Fab	Composite	Supplier	
Work Order: _____		MRB (QS042) Approval			
Part No. _____					
NCR No. _____					
Date: _____					
Step #: _____					
Description Work Order Deviation		Disposition			
Root Cause		Completed By			
Environment		Lead hand / Supervisor			
Design		Approval Verification			
Doc/Data					
Equip/Tooling					
Handling/Pre					
Material					
Internal Transport					
Tribal Knowledge					
LOA					
Substation					
Past Expiry Date					
Misidentified					
No Re-verification					
Operator					
Offset/Setup					
Supplier					
Training					
Use for Testing					
Poor Information					
Rushing					
Product Improvement					
Process Improvement					
Manufacturing Process					
Past Due					
Pressure/Forced					
Bending					
Centre Not Concentric					
Cracks					
Crimp/Kink/Ripple/Wave					
Cuffs					
Crushing					
Heat Treat					
Wave/Twist in Tube					
Marks/Chatter					
OTHER :					



Container No: S092787



Part: D3488 - 041

Job No: 179050

Serial No/Batch: S092787

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/17/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com